



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D5955**

**Job Sheet 173834**



**Part No:** D5955

**Job Qty:** 6 ea

**Part Name:** Saddle



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 3/7/18

**Job Tracking No:**

**Due Date:** 4/12/18

**Created By:** Linda Lacelle

**Type:** SOLD

**Description:**

**Note:** DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:F ecn826 06.12.06 ec

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                        |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation     | 6 Ea  | 4/11/18    | 4/11/18  | 0.00      | 0.00    | Start Up Machining-4  |           | JH8         |
| 100   | CNC Vertical Machining | 6 pcs | 4/11/18    | 4/11/18  | 0.32      | 16.67   | HAAS1-5               |           |             |
| 110   | QC                     | 6 pcs | 4/11/18    | 4/11/18  | 0.00      | 0.00    | QC1                   |           |             |
| 120   | QC                     | 6 pcs | 4/11/18    | 4/11/18  | 0.00      | 0.00    | QC8 Machining-4       |           | OK 18/03/27 |
| 130   | HandFinish             | 6 pcs | 4/11/18    | 4/11/18  | 0.00      | 0.52    | HandFinish1           |           | SA 18-03-28 |
| 140   | Powdercoat             | 6 pcs | 4/12/18    | 4/12/18  | 0.00      | 0.28    | Powdercoat1           |           | BR 18-3-28  |
| 150   | QC                     | 6 pcs | 4/12/18    | 4/12/18  | 0.00      | 0.00    | QC3                   |           |             |
| 160   | Packaging              | 6 pcs | 4/12/18    | 4/12/18  | 0.00      | 0.00    | Packaging3-2          |           | 57399       |
| 170   | QC21-SA                | 6 Ea  | 4/12/18    | 4/12/18  | 0.00      | 0.00    | QC21                  |           | APR 02 2018 |

Part Op 100 - 1-Machine as per folio D5955, Ensure Batch Number is entered

Descriptions: 110 - Inspect on CMM as per folio CMM A018

140 - START TIME: 11:50

OUT: 3:20 FINISH: 12:00

M138760

21

APR 02 2018

### Job BOM

| Part / Item | Component Name | Quantity    | Operation             | Container |
|-------------|----------------|-------------|-----------------------|-----------|
| D6101-013   | Saddle Billet  | 6 Ea (1 ea) | 90-Start up Operation |           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D6101-013      | 6        | 24        | 0         |

### Part Specifications

Specifications could not be found.

F DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                      |  |                                                                                                                                                                                |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |  |                       |                                              |  |  |
|------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|-----------------------|----------------------------------------------|--|--|
| Work Order: _____<br>Part No. _____<br>NCR No. _____ |  | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |  | <b>AGAINST DEPARTMENT/PROCESS</b><br>Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Thermoforming <input type="checkbox"/><br>Large Fab <input type="checkbox"/><br>Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/><br>Composite <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Engineering <input type="checkbox"/><br>Quality <input type="checkbox"/><br>Other <input type="checkbox"/> |  |  |                       |                                              |  |  |
| Date : _____                                         |  | Step #: _____                                                                                                                                                                  |  | QTY Effective : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |  | MRB (QS1042) Approval |                                              |  |  |
| Description Work Order Deviation                     |  |                                                                                                                                                                                |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |                       | Completed By                                 |  |  |
|                                                      |  |                                                                                                                                                                                |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |  |                       | Lead hand / Supervisor Approval Verification |  |  |
|                                                      |  |                                                                                                                                                                                |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |  |                       | QC / QA Coordinator Approval                 |  |  |
|                                                      |  |                                                                                                                                                                                |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |  |                       |                                              |  |  |

| FAULT CATEGORY    |                                                |                                               |
|-------------------|------------------------------------------------|-----------------------------------------------|
| Effect            | <input type="checkbox"/> Power Loss/Surge      | <input type="checkbox"/> Positioned Wrong     |
|                   | <input type="checkbox"/> Folio/Program         | <input type="checkbox"/> Outside Dimensions   |
|                   | <input type="checkbox"/> Grain                 | <input type="checkbox"/> Over/Under tolerance |
|                   | <input type="checkbox"/> Weld                  | <input type="checkbox"/> Part Incorrect       |
| Cause/Unqualified | <input type="checkbox"/> Wrong Stock Pulled    | <input type="checkbox"/> Part Lost/Missing    |
|                   | <input type="checkbox"/> Out of Sequence       | <input type="checkbox"/> Part Moved           |
|                   | <input type="checkbox"/> Off-set               | <input type="checkbox"/> Drawing              |
|                   | <input type="checkbox"/> Mislabeled            | <input type="checkbox"/> Finish               |
| Complete/Unclear  | <input type="checkbox"/> Fit/Function          | <input type="checkbox"/> Misread              |
|                   | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Turning Sequence     |
|                   |                                                |                                               |

Drill Holes

OTHER : \_\_\_\_\_

Date: 03/24/19

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawthorn, ON K6A 1K7  
CANADA  
TEL: 1-800-382-5200  
Email: sales@dartaero.com  
www.dartaero.com



Container No: S054573

Part: D5955  
Job No: 173834  
Serial No/Batch: S054573

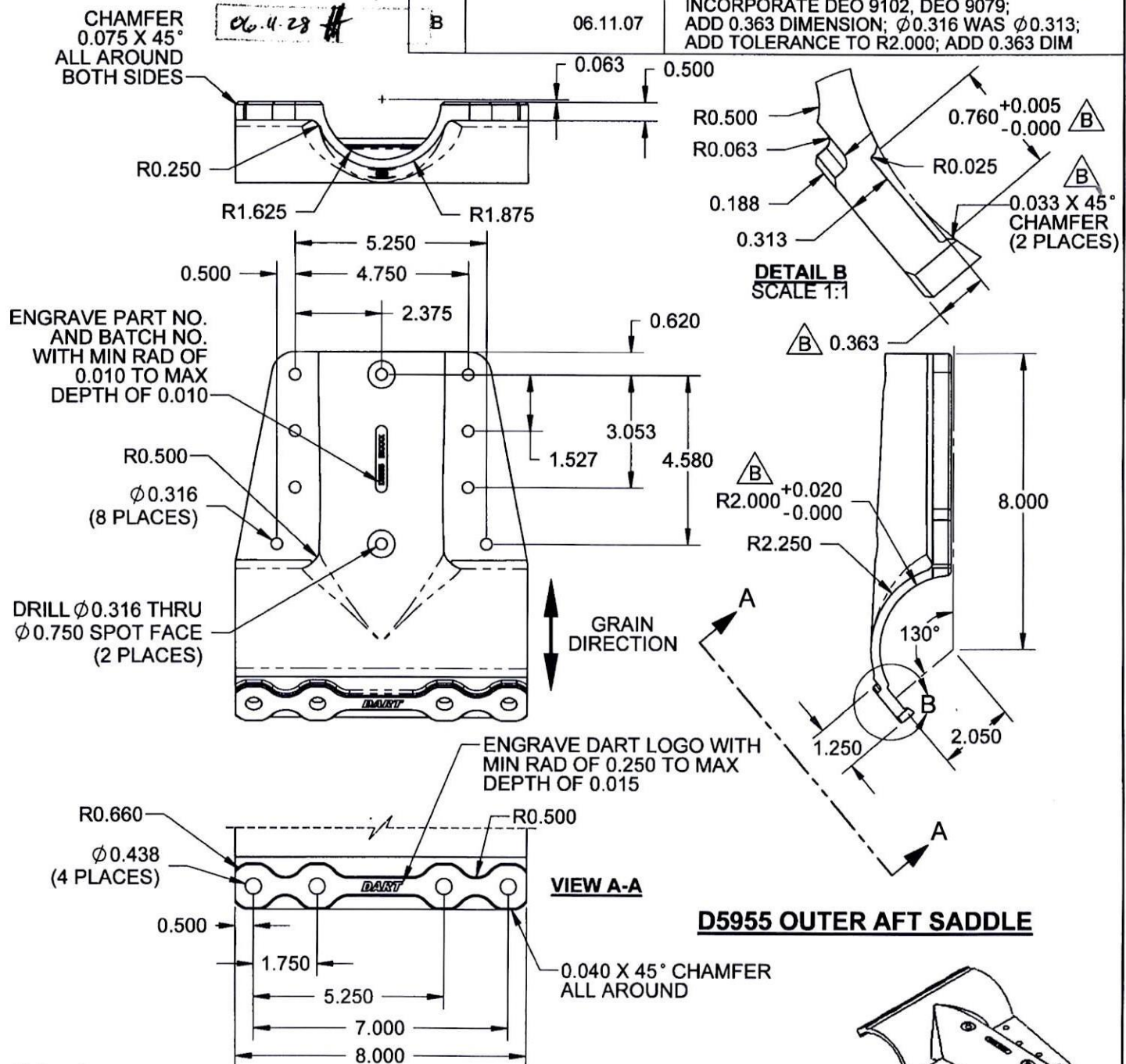
Revision:  
Inspector:



SUBJECT: **DART**  
WITH: **WORK ORDER**  
NO. **17.3834 msl**

|                         |                                  |                                                                                                                                   |                        |
|-------------------------|----------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|------------------------|
| DESIGN<br><b>BW</b>     | DRAWN BY<br><b>CB</b>            | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                          |                        |
| CHECKED<br><b>LE</b>    | APPROVED<br><b>HA</b>            | DRAWING NO.<br><b>D5955</b>                                                                                                       | REV. B<br>SHEET 1 OF 1 |
| DATE<br><b>06.11.07</b> | TITLE<br><b>OUTER AFT SADDLE</b> |                                                                                                                                   |                        |
| REV<br><b>A</b>         | DATE<br><b>97.05.06</b>          | DESCRIPTION<br><b>NEW ISSUE</b>                                                                                                   |                        |
| <b>B</b>                | <b>06.11.07</b>                  | INCORPORATE DEO 9102, DEO 9079;<br>ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ;<br>ADD TOLERANCE TO R2.000; ADD 0.363 DIM |                        |

MAR 07 2018



**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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|                                      |               |                           |
|--------------------------------------|---------------|---------------------------|
| <b>DART AEROSPACE LTD</b>            |               | <b>Work Order:</b> 173834 |
| <b>Description:</b> Outer Aft Saddle |               | <b>Part Number:</b> D5955 |
| <b>Inspection Dwg:</b> D5955         | <b>Rev:</b> B | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing and record below:

|               |       |       |                | Recorded Actual Dimensions |        |        |        | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2      | 3      | 4      |    |      |
| A             | 0.438 | 0.443 |                | 0.438                      | 0.438  | 0.438  | 0.438  |    |      |
| B             | 1.745 | 1.755 |                | 1.749                      | 1.749  | 1.749  | 1.749  |    |      |
| C             | 5.245 | 5.255 |                | 5.250                      | 5.250  | 5.250  | 5.250  |    |      |
| D             | 6.995 | 7.005 |                | 7.000                      | 7.000  | 7.000  | 7.000  |    |      |
| E             | 5.240 | 5.260 |                | 5.245                      | 5.245  | 5.245  | 5.245  |    |      |
| F             | 4.745 | 4.755 |                | 4.745                      | 4.745  | 4.745  | 4.745  |    |      |
| G             | 0.315 | 0.322 |                | 0.316                      | 0.316  | 0.316  | 0.316  |    |      |
| H             | 1.522 | 1.532 |                | 1.524                      | 1.524  | 1.524  | 1.524  |    |      |
| I             | 3.048 | 3.058 |                | 3.052                      | 3.052  | 3.052  | 3.052  |    |      |
| J             | 4.575 | 4.585 |                | 4.582                      | 4.582  | 4.582  | 4.582  |    |      |
| K             | 0.315 | 0.322 |                | 0.316                      | 0.316  | 0.316  | 0.316  |    |      |
| L             | 0.495 | 0.505 |                | 0.497                      | 0.497  | 0.497  | 0.497  |    |      |
| M             | 0.490 | 0.510 |                | 0.500                      | 0.500  | 0.500  | 0.500  |    |      |
| N             | 1.865 | 1.885 |                | R1.875                     | R1.875 | R1.875 | R1.875 |    |      |
| O             | 7.990 | 8.010 |                | 8.000                      | 8.000  | 8.000  | 8.000  |    |      |
| P             | 2.240 | 2.260 |                | R2.250                     | R2.250 | R2.250 | R2.250 |    |      |
| Q             | 0.307 | 0.312 |                | 0.310                      | 0.313  | 0.313  | 0.313  |    |      |
| R             | 0.760 | 0.765 |                | 0.761                      | 0.760  | 0.760  | 0.760  |    |      |
| S             | 0.490 | 0.510 |                | 0.501                      | 0.502  | 0.502  | 0.502  |    |      |
| T             | 1.625 | 1.645 |                | R1.625                     | R1.625 | R1.625 | R1.625 |    |      |
| U             | 2.000 | 2.020 |                | R2.000                     | R2.000 | R2.000 | R2.000 |    |      |
| V             | 0.023 | 0.043 |                | 0.033                      | 0.033  | 0.033  | 0.033  |    |      |
| W             |       |       |                |                            |        |        |        |    |      |
| X             |       |       |                |                            |        |        |        |    |      |
| Y             |       |       |                |                            |        |        |        |    |      |
| Z             |       |       |                |                            |        |        |        |    |      |
| AA            |       |       |                |                            |        |        |        |    |      |
| AB            |       |       |                |                            |        |        |        |    |      |
| AC            |       |       |                |                            |        |        |        |    |      |
| AD            |       |       |                |                            |        |        |        |    |      |
| AE            |       |       |                |                            |        |        |        |    |      |
| AF            |       |       |                |                            |        |        |        |    |      |
| Accept/Reject |       |       |                |                            |        |        |        |    |      |

|                  |
|------------------|
| Measured by: VHS |
| Date: 18/03/25   |

|                         |
|-------------------------|
| Audited by: [Signature] |
| Date: 18/03/27          |

| Rev | Date     | Change                                    | Revised by | Approved |
|-----|----------|-------------------------------------------|------------|----------|
| A   | 99.04.19 | New Issue                                 | RF         |          |
| B   | 02.12.13 | Reformat; Added Dim. T-U & DT8682, DT8686 | KJ/RF      |          |
| C   | 06.11.20 | Added dimension V                         | KJ/JLM     |          |
| D   | 06.12.06 | Dimensions L,N,P revised                  | KJ/EC      |          |
| E   | 07.06.15 | Dimension G revised                       | KJ/JLM     |          |
| F   | 08.04.21 | Dimension E revised                       | KJ/DD      |          |
| G   | 08.08.05 | Dimension K revised                       | KJ/DD      |          |



|                                      |               |                           |
|--------------------------------------|---------------|---------------------------|
| <b>DART AEROSPACE LTD</b>            |               | <b>Work Order:</b> 173834 |
| <b>Description:</b> Outer Aft Saddle |               | <b>Part Number:</b> D5955 |
| <b>Inspection Dwg:</b> D5955         | <b>Rev:</b> B | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |        |   |   | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|---|---|----|------|
|               |       |       |                | 15                         | 26     | 3 | 4 |    |      |
| A             | 0.438 | 0.443 |                | 0.438                      | 0.438  |   |   |    |      |
| B             | 1.745 | 1.755 |                | 1.749                      | 1.749  |   |   |    |      |
| C             | 5.245 | 5.255 |                | 5.250                      | 5.250  |   |   |    |      |
| D             | 6.995 | 7.005 |                | 7.000                      | 7.000  |   |   |    |      |
| E             | 5.240 | 5.260 |                | 5.245                      | 5.245  |   |   |    |      |
| F             | 4.745 | 4.755 |                | 4.745                      | 4.745  |   |   |    |      |
| G             | 0.315 | 0.322 |                | 0.316                      | 0.316  |   |   |    |      |
| H             | 1.522 | 1.532 |                | 1.524                      | 1.524  |   |   |    |      |
| I             | 3.048 | 3.058 |                | 3.052                      | 3.052  |   |   |    |      |
| J             | 4.575 | 4.585 |                | 4.582                      | 4.582  |   |   |    |      |
| K             | 0.315 | 0.322 |                | 0.316                      | 0.316  |   |   |    |      |
| L             | 0.495 | 0.505 |                | 0.497                      | 0.497  |   |   |    |      |
| M             | 0.490 | 0.510 |                | 0.500                      | 0.501  |   |   |    |      |
| N             | 1.865 | 1.885 |                | 1.875                      | 1.875  |   |   |    |      |
| O             | 7.990 | 8.010 |                | 7.999                      | 7.999  |   |   |    |      |
| P             | 2.240 | 2.260 |                | 2.23                       | 2.23   |   |   |    |      |
| Q             | 0.307 | 0.312 |                | 0.310                      | 0.310  |   |   |    |      |
| R             | 0.760 | 0.765 |                | 0.760                      | 0.760  |   |   |    |      |
| S             | 0.490 | 0.510 |                | 0.502                      | 0.5025 |   |   |    |      |
| T             | 1.625 | 1.645 |                | 1.625                      | 1.625  |   |   |    |      |
| U             | 2.000 | 2.020 |                | 2.00                       | 2.00   |   |   |    |      |
| V             | 0.023 | 0.043 |                | 0.033                      | 0.033  |   |   |    |      |
| W             |       |       |                |                            |        |   |   |    |      |
| X             |       |       |                |                            |        |   |   |    |      |
| Y             |       |       |                |                            |        |   |   |    |      |
| Z             |       |       |                |                            |        |   |   |    |      |
| AA            |       |       |                |                            |        |   |   |    |      |
| AB            |       |       |                |                            |        |   |   |    |      |
| AC            |       |       |                |                            |        |   |   |    |      |
| AD            |       |       |                |                            |        |   |   |    |      |
| AE            |       |       |                |                            |        |   |   |    |      |
| AF            |       |       |                |                            |        |   |   |    |      |
| Accept/Reject |       |       |                |                            |        |   |   |    |      |

|              |          |
|--------------|----------|
| Measured by: | UHS      |
| Date:        | 18/03/25 |

|             |          |
|-------------|----------|
| Audited by: | mf       |
| Date:       | 21/03/27 |

| Rev | Date     | Change                                    | Revised by | Approved |
|-----|----------|-------------------------------------------|------------|----------|
| A   | 99.04.19 | New Issue                                 | RF         |          |
| B   | 02.12.13 | Reformat; Added Dim. T-U & DT8682, DT8686 | KJ/RF      |          |
| C   | 06.11.20 | Added dimension V                         | KJ/JLM     |          |
| D   | 06.12.06 | Dimensions L,N,P revised                  | KJ/EC      |          |
| E   | 07.06.15 | Dimension G revised                       | KJ/JLM     |          |
| F   | 08.04.21 | Dimension E revised                       | KJ/DD      |          |
| G   | 08.08.05 | Dimension K revised                       | KJ/DD      |          |